

SPLIT

Date: Wednesday, 11/03/2009 12:58:50 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 46433 -2		Part Number	: D2572		
Estimate Number	: 10531		Drawing Number	: D2572 REV E		
P.O. Number	:		Project Number	: N/A		
This Issue	: 11/03/2009 S.O. No. :		Drawing Revision	: E		
Prsht Rev.	: NC		Material	:		
First Issue	: 11 Type : MACHINED PARTS		Due Date	: 04/04/2009		
Previous Run	: 45922		Qty:	12	Um:	Each
Written By	:					
Checked & Approved By	: JD 09-03-11					
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	Saddle Billet	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: B34874			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: 46433 Double check by: MNF			
1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.			
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572			

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)	
Job Number: 46433		Part Number: D2572	
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		JL / mwf 09/04/07	
5.0	QC8	SECOND CHECK 	
Comment: SECOND CHECK		mwf 09/04/13 (7)	
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 	
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		gbl 09-04-14 (X7)	
7.0	POWDER COATING	POWDER COATING 	
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		M110939. (7)	
START TIME: <u>3:45</u>			
OVEN TEMPERATURE: <u>320</u>			
FINISH TIME: <u>4:15</u>		BL 09-04-14	
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 	
Comment: INSPECT POWDER COAT		09-04-15 (X7)	
9.0	PACKAGING 1	PACKAGING RESOURCE #1 	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>ST433</u>		A 09-04-15 B	
10.0	QC21	FINAL INSPECTION/W/O RELEASE 	
Comment: FINAL INSPECTION/W/O RELEASE		09/04/15 JG	
Job Completion 		MF 09-04-15	

DART AEROSPACE LTD				Work Order: H10433	
Description: Saddle, Fwd Inboard			Part Number: D2572		
Inspection Dwg: D2572 Rev. E			Page 1 of 1		

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.441	.440	.440	.440		
B	1.745	1.755		1.750	1.747	1.747	1.747		
C	3.495	3.505		3.500	3.499	3.498	3.500		
D	1.745	1.755		1.750	1.747	1.747	1.748		
E	7.990	8.010		8.000	8.002	8.001	8.003		
F	0.490	0.510		.497	.498	.500	.499		
G	0.257	0.262		.259	.258	.258	.258		
H	0.375	0.380		.376	.375	.377	.376		
I	0.490	0.510		.502	.508	.508	.506		
J	1.174	1.184		1.179	1.178	1.178	1.178		
K	0.558	0.578		.569	.576	.573	.575		
L	1.174	1.184		1.179	1.178	1.178	1.178		
M	1.490	1.500		1.495	1.495	1.494	1.494		
N	2.495	2.505		2.500	2.499	2.500	2.499		
O	3.869	3.879		3.874	3.874	3.874	3.872		
P	0.115	0.135		.125	.124	.124	.129		
Q	0.115	0.135		.135	.135	.135	.134		
R	0.240	0.260		.250	.250	.251	.251		
S	0.115	0.135		.128	.128	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.958	2.958	2.959		
V	0.230	0.250		.239	.240	.240	.239		
W	0.115	0.135		.129	.130	.130	.139		
X	0.307	0.312		.310	.312	.313	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.363	.364	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.625	.625	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.243	.250	.250		
AE	1.375	1.395		1.390	1.391	1.392	1.393		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.246	.245	.245	.242		
AI	2.000	2.020		2.005	2.006	2.008	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	J1	Audited by:	Onf
Date:	09/04/05	Date:	09/04/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	Onf

DART AEROSPACE LTD

Work Order:

410433

Description: Saddle, Fwd Inboard

Part Number:

D2572

Inspection Dwg: D2572 Rev. E

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1 5	2 6	3 7	4 8		
A	0.438	0.443		.440	.441	.441	.440		
B	1.745	1.755		1.746	1.750	1.750	1.750		
C	3.495	3.505		3.496	3.500	3.500	3.500		
D	1.745	1.755		1.746	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.001	8.000	8.001		
F	0.490	0.510		.500	.503	.502	.502		
G	0.257	0.262		.258	.258	.259	.259		
H	0.375	0.380		.377	.378	.376	.376		
I	0.490	0.510		.507	.506	.510	.510		
J	1.174	1.184		1.177	1.178	1.179	1.179		
K	0.558	0.578		.575	.573	.578	.578		
L	1.174	1.184		1.178	1.178	1.179	1.179		
M	1.490	1.500		1.497	1.495	1.495	1.495		
N	2.495	2.505		2.493	2.500	2.500	2.500		
O	3.869	3.879		3.870	3.871	3.874	3.874		
P	0.115	0.135		.125	.125	.124	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.249	.250	.250		
S	0.115	0.135		.130	.129	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.957	2.958	2.960	2.960		
V	0.230	0.250		.238	.238	.239	.240		
W	0.115	0.135		.129	.125	.123	.125		
X	0.307	0.312		.312	.312	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.363	.364	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.628	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.244	.243	.242		
AE	1.375	1.395		1.391	1.391	1.391	1.391		
AF	0.115	0.135		.122	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.263	.246	.244	.245		
AI	2.000	2.020		2.008	2.005	2.005	2.006		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	J.L
Date:	09/04/13

Audited by:	J.M
Date:	09/04/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	J.M

DART AEROSPACE LTD				Work Order:	46433
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

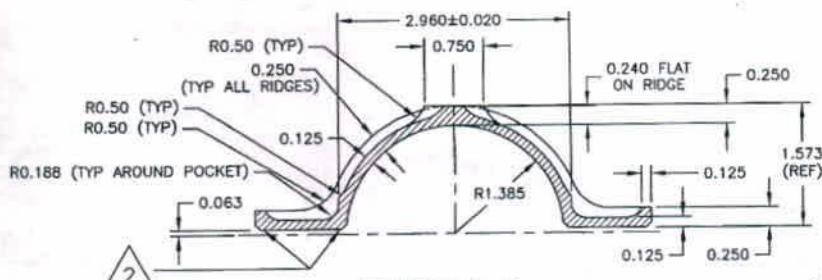
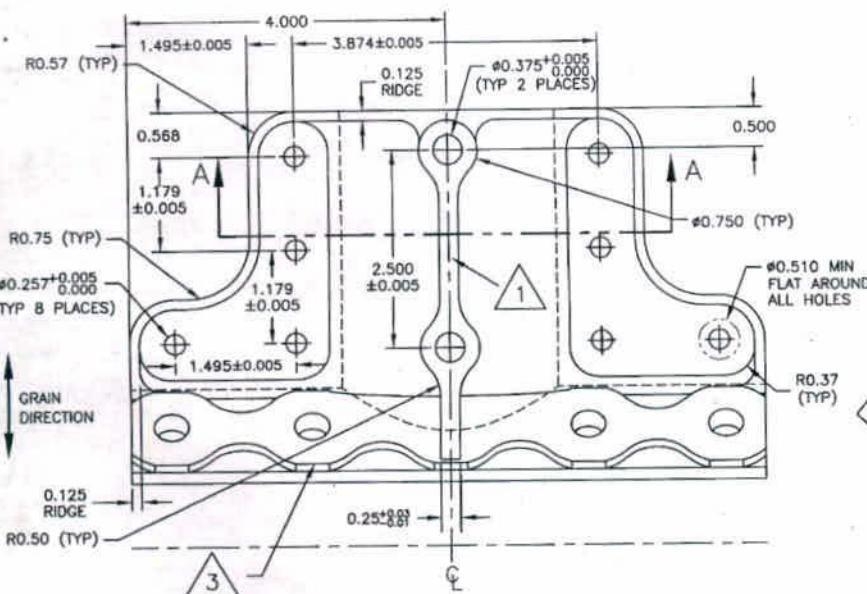
Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				79	810	811	812		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.746	1.746	1.748	1.748		
C	3.495	3.505		3.499	3.499	3.499	3.500		
D	1.745	1.755		1.748	1.746	1.747	1.748		
E	7.990	8.010		8.003	8.004	8.004	8.001		
F	0.490	0.510		.491	.506	.500	.498		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.501	.500	.499	.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.569	1.741	.563		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.130	.131	.127	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.954	2.958		
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W	0.115	0.135		.135	.134	.135	.135		
X	0.307	0.312		.310	.310	.309	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.364	.367	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.627	.625	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.244	.245	.248		
AE	1.375	1.395		1.390	1.391	1.390	1.389		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.246	.246	.246	.247		
AI	2.000	2.020		2.004	2.005	2.004	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		

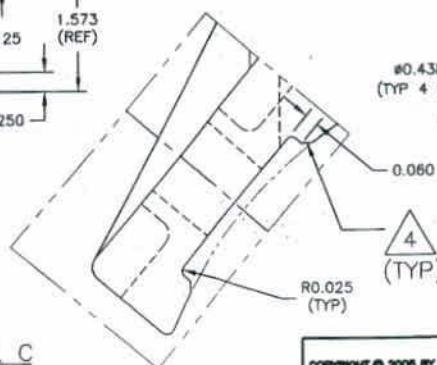
Accept/Reject

Measured by:	JL / mnf	Audited by:	JL
Date:	09/04/11	Date:	09/04/13

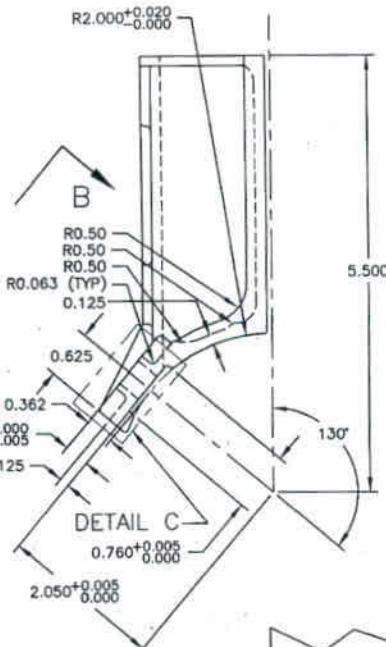
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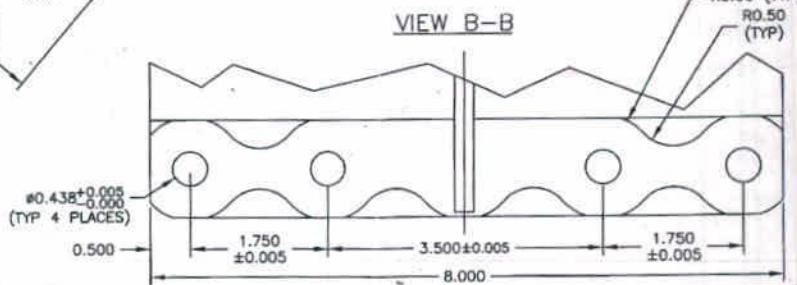
SECTION A-A



DETAIL C
SCALE 2:1



VIEW B-1



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E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS	DRAWN BY PH	DART DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2572
DATE 05.07.13	TITLE INNER FWD SADDLE	REV. E SHEET 1 OF 1 SCALE 2:3

~~RELEASED~~
05.12.06 *tt*